

Date: Monday, 14/11/2005 8:21:56 AM
 User: Alba Panzuto

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 24401		
Estimate Number	: 10310		
P.O. Number	:	Part Number	: D26175
This Issue	: 14/11/2005 S.O. No. : N/A	Drawing Number	: D2617 REV D2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: D2
Previous Run	: N/A	Material	: N/A
Written By	: <u>See comment below</u>	Due Date	: 15/12/2005 Qty: 50 Um: Each
Checked & Approved By	: <u>See comment below</u>		
Comment	: Est H 04.07.14 Reformat; added step 5KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0500W058	6061-T6 Tube .500 x.058W
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
	Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA438 and Dwg D2617 Ø0.500" tubing x 0.058" wall <u>M18740</u> <u>ml 05/11/22</u> <u>50</u>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>gml</u> <u>05/11/22</u> <u>50</u>	
4.0	QC8	SECOND CHECK <u>J.L</u> <u>05/11/23</u> <u>50</u>
	Comment: SECOND CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
	Comment: Deburr break all unmarked sharp edges 0.005 to 0.010 <u>DL</u> <u>05/11/23</u> <u>50</u>	
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT ALODINE <u>SAD</u> <u>05/11/27</u> <u>50</u>	
7.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
	Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1 <u>J</u> <u>05.11.20</u> <u>50</u>	

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Seq. #:

Machine Or Operation:

Description :

8.0

QC5

INSPECT WORK TO CURRENT STEP



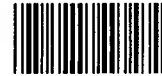
Comment: INSPECT WORK TO CURRENT STEP

J 05.11.28 50

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 49

C 05/11/28 50

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

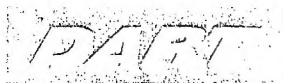
Suc 05/11/29 (50)

PS 05/11/29 50

Job Completion

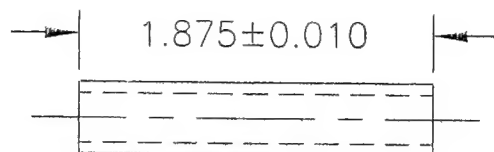


CONTROLLED COPY

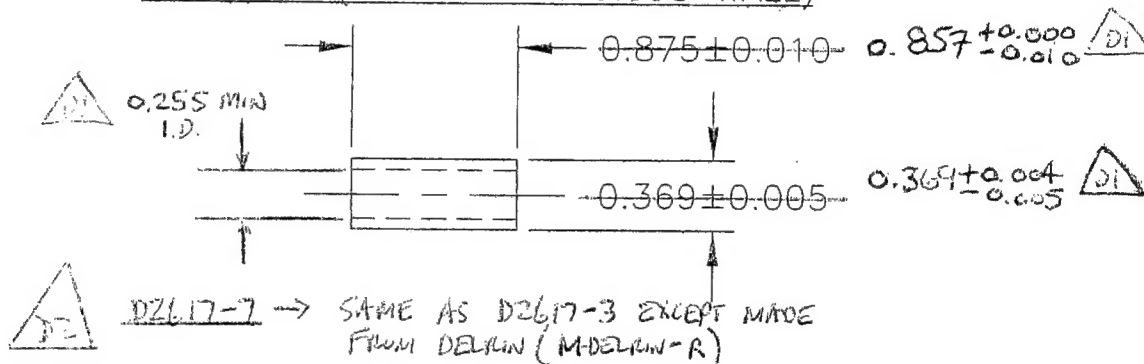


DESIGN BW	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2617	REV. D SHEET 1 OF 1
DATE 01.07.04	TITLE BUSHING SCALE 1:1		
A	96.10.08	NEW ISSUE	
B	97.05.08	.875 WAS 1.125	
C	97.06.04	0.369 DIA WAS 0.375	
D	01.07.04	ADD MAT'L SPEC AND TOL./DIM. NOTE	
DI	CP	04.07.12	CORRECT TOLERANCE (NCR 779)

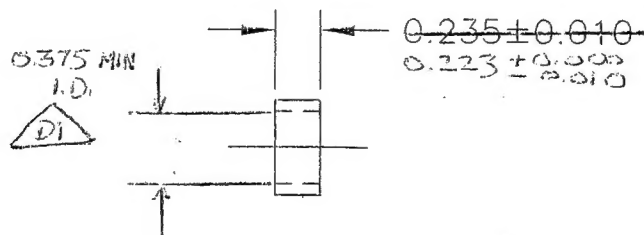
D2617-1 (0.375 OD x 0.058 WALL)



D2617-3 (0.375 OD x 0.058 WALL)



D2617-5 (0.500 OD x 0.058 WALL)



RELEASED
01.07.05

NOTES:

- 1) MATERIAL: 5052-H32 (QQ-A-225/7 OR WW-T-700/4)
OR 6061-T6 (QQ-A-225/8, QQ-A-200/8, OR WW-T-700/6)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: ACID ETCH, ALODINE PER QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Nov 08, 2005
12:06 pm

Work Order No : 0024401
Project Name : D2617-5
Project For : WK542
Work Order Type : Main
Main WO Number :
House Part Number : D2617-5
Description : Spacer
Manufactured : Yes
Amount Req'd : 50
Amount Done : 0
Start Date : 10-03-05
Est Finish Date : 10-20-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00.	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	2.50	100.00		
Production Cost	0.00	33.45	100.00	0.00	33.45
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	2.50	100.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	33.45	100.00		
Margin	0.000	0.000			
Selling Cost	0.00	33.45			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	(-33.45)

MIS d/B
u
11.13

